

Date: Thursday, 01/05/2008 11:57:03 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : AFT DOUBLER

Job Number : 38947

Estimate Number : 13151

P.O. Number :

This Issue : 01/05/2008

S.O. No. :

Prsht Rev. : NC

First Issue : / /

Type : SMALL / MED FAB

Previous Run : 38840

Part Number : D37035

Drawing Number : D3703 PRELIM

Project Number : N/A

Drawing Revision : PRELIM

Material :

Due Date : 05/05/2008

Qty:

28 Um:

Each

Written By :

Checked & Approved By :

Comment : Est Rev:A 08-04-24 new issue DD verified by:EC

Additional Product

PROTOTYPE PRELIMINARY ISSUE

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6S063

6061-T6 .063 Sheet



Comment: Qty.: 0.0833 sf(s)/Unit Total : 0.4163 sf(s)

6061T6 aluminium sheet .063" thick

(M6061T6S063)

Batch: 107387

HB 8-5-1

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3703

Dwg Rev: PREL

Prog Rev: PREL

HB 8-5-1

2- Deburr if necessary

HB 8-5-1

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

**ENGINEERING
APPROVAL**



Comment: SECOND CHECK

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Not required HB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 11:57:03 AM
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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Not required

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

08-05-21

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08-05-22

Job Completion



Prototype

MF 08-06-13

Dart Aerospace Ltd

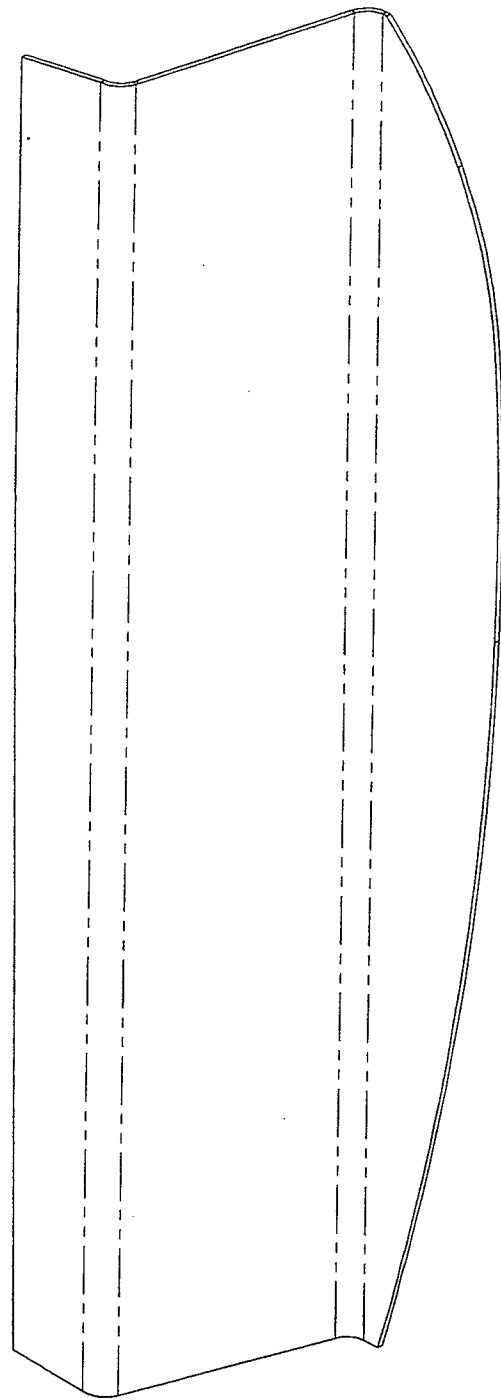
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

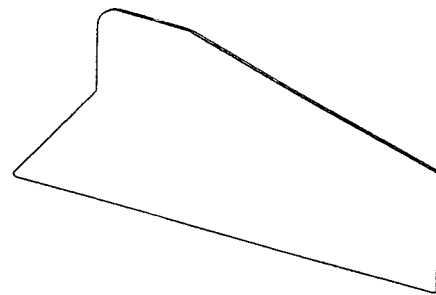
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

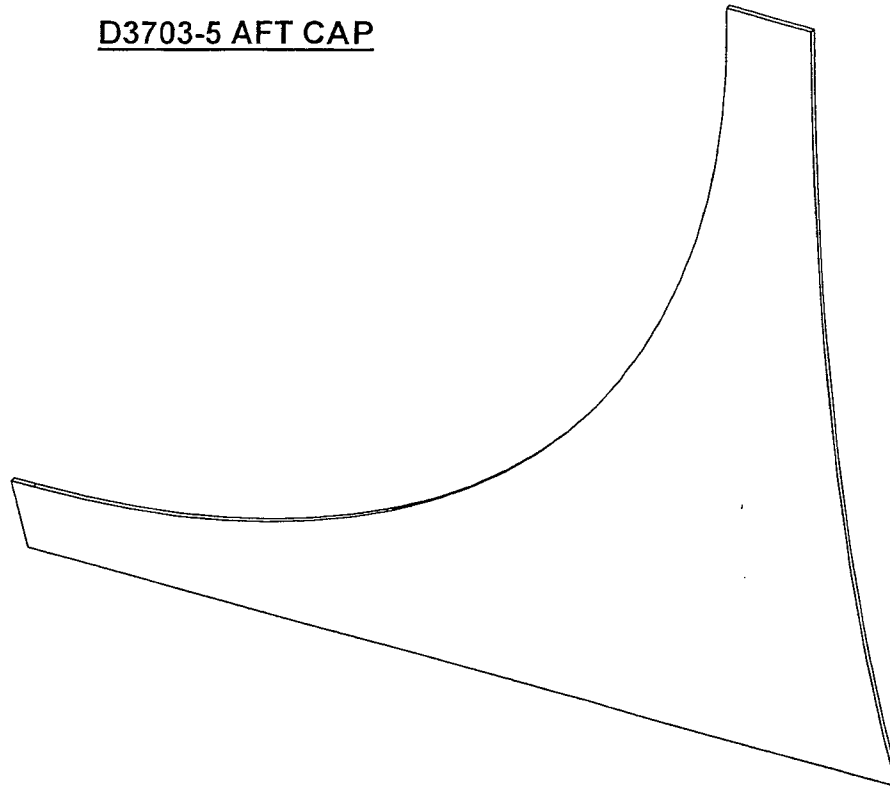
NOTE: Date & initial all entries



D3703-1 AFT DOUBLER



D3703-5 AFT CAP



D3703-3 AFT CORNER DOUBLER

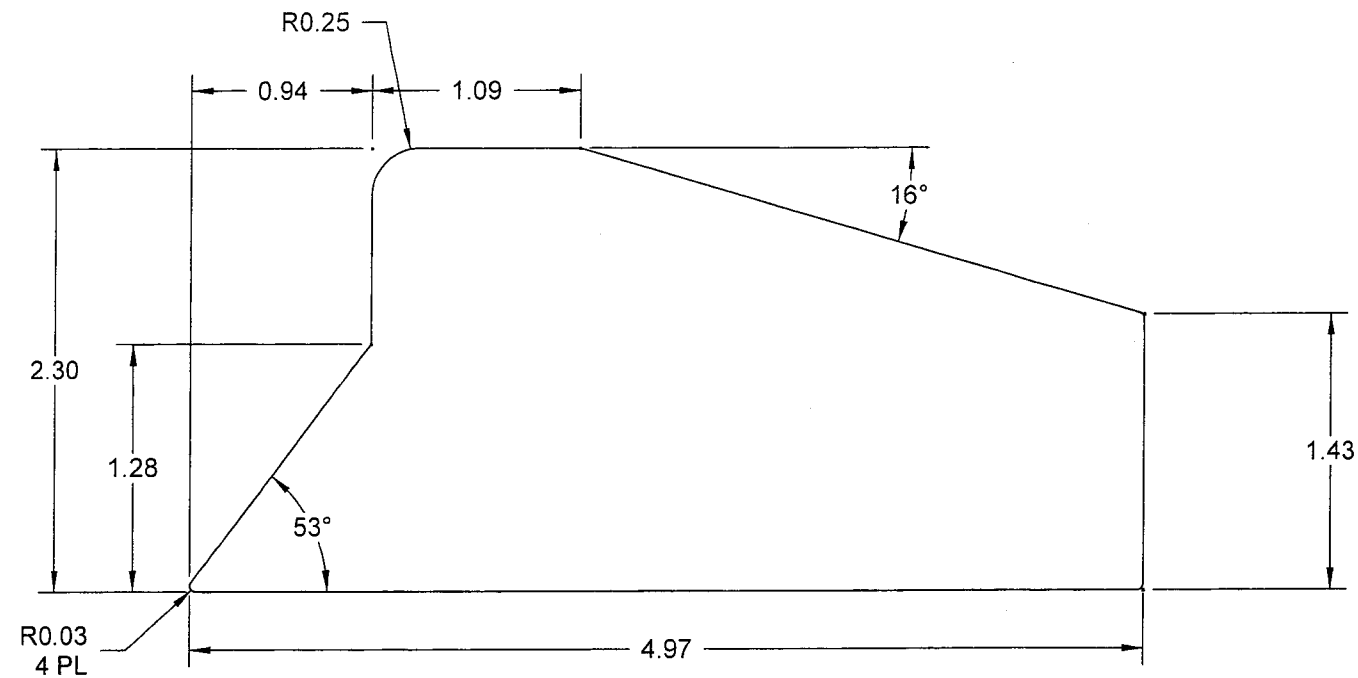
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3703-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3703-1 = 0.56 lbs
D3703-3 = 0.23 lbs
D3703-5 = 0.03 lbs

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38947

PROTOTYPE
PRELIMINARY ISSUE
08.04.30

A	NEW ISSUE	MB	08.04.30
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3703	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		AFT DOUBLER	NTS
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D3703-5 AFT CAP

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NO. 38947

PROTOTYPE

PRELIMINARY ISSUE

2008.04.30

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MFG. APPR.			SHEET 4 OF 4
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MAGNA STAINLESS DIV. DE CSM INC.
525 MELOCHE AVE.
DORVAL, QUEBEC H9P 2W2
(514) 631-1211 FAX: (514) 631-

VENDU À /
SOLD TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO

K6A 1K7

LIVRÉ À /
SHIP TO:

NUMÉRO SALES ORDER	CODE DE CLIENT CUSTOMER CODE	BON D'ACHAT DU CUSTOMER PURCHASE
0165970	DART	5851
LIVRÉ VIA / SHIP VIA	CONDITIONS / TERMS	DATE COMMANDE DATE ORDER
NIR:R-557065-1	NET 30	Mar-

CONTRÔLE DE QUALITÉ DOCUMENT REQUIS CUSTOMER QUALITY RELEASE REQ'D		CONTRÔLE DE QUALITÉ D MAGNA QUALITY	
QUALITÉ / QUALITY	UNITÉ / UNIT	N° DE COULÉE / HEAT NUMBER	DESCRIPTION
COMMANDE / ORDERED	A VENDRE / B/O		

4Pcs 8	1bs	F8153CR	304L ROUND 1/4" DIA
2Pcs 26	1bs	41043	6061-T6 ALUM 3/4 SQ USE MTR #CA533
3P 131	1bs	1628331	6061-T6 .063 X 48 X USE MTR #BZ853
5Pcs 443	1bs	426603	6061-T6 AL FLAT 1 1 USE MTR #CE459
TOTAL :			

OMBRE DE PAQ. NUMBER OF BOL'S	MTR-AVEC COMMANDE MTR'S-WITH ORDER	POSTE MAIL	TÉLÉCOPIEUR FAX
1	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

Age: 1
08:50:24 20080311

N° DE COULÉE ÉTAMPER SUR LE CÔTÉ
HEAT NO. STAMP ONE END

MATÉRIEL REÇU EN BON ÉTAT PAR / MATERIAL RECEIVED IN GOOD CONDITIONS BY:

H:\FORMS\Purchasing\approved purchase\REPORT Rev D

Production/Admin:
Date
Received/Costing
Initial

Location

Initials of receiver (if shipment OK) Level 12

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M204T8040		108	0	0	108	
M601T63100X015		20			20	

Discrepancies

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☒ No ☐
Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐
Waybill Attached: Yes ☒ No ☐
Shipment Complete: Yes ☒ No ☐
QC6 Inspection: Yes ☒ No ☐
Work Order: N/A

Date: 8/3/12
Supplier: MAGNA

Batch No: M1.7367
Part P/O: 5851

Receiving report

BZ 853

DOC : V/0080236963

DATE : 2007-05-30

PROD. REF. : 0000217536/004

NREB : 03484/04

PAGE : 1/ 2

INSPECTION CERTIFICATE



CUSTOMER : ALERIS ALUMINUM US SALES INC.

Aleris Aluminum Duffel BVBA
A. Stockhousen 87, 2570 Duffel - Belgium

YOUR ORDER NUMBER : P08858 (CHARLESTON PO#5001-E)
OUR ORDER NUMBER : 03484/04
DOCUMENT NUMBER : V/0080236963

DESCRIPTION : ALU SHEETS (STENC) AA 6061-T6 AMS-QQA 250/11 AMS 4027M ASTM B209-04
DIMENSIONS : 144" X 48" X .063"
ARTICLE NO. :

08/3/12

COIL
NUMBER

CAST
NUMBER

CHEMICAL COMPOSITION (%)

	MIN	SI	FE	CU	MN	MG	CR	TI	ZN
	MAX	0,40		0,15		0,8	0,04		
		0,8	0,7	0,40	0,15	1,2	0,35	0,15	0,25
004		0,62	0,4	0,19	0,07	1,0	0,15	0,03	0,05
005		0,68	0,4	0,20	0,08	1,0	0,17	0,02	0,03

OTHERS : EACH : MIN
TOTAL : MIN

0,05 MAX
0,15 MAX

MECHANICAL PROPERTIES

TEST-
NUMBER

(T) = TRANSVERSAL (L) = LONGITUDINAL
1 N/MM2 = 1 MPA = 0,1 HBAR 0,102 KG/MM2 = 0,145 KSI
/A = REAR END /M = MIDDLE /F = FRONT END /O = RANDOM SAMPLING

	RM	RP02	A
	KSI	KSI	%
	42	35	10
004	/A	50	42
004	/M	49	42
004	/V	50	41
005	/A	50	41
005	/M	50	41
005	/V	50	41

Aleris Aluminum Duffel BVBA

59983
24/12

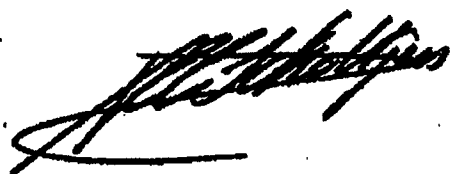
Aleris

Europe

Aleris Aluminium Duffel BVBA
A. Stockmans 87, 2870 Duffel - Belgium

DATE SOLUTION HEAT TREATMENT COIL NUMBER
004 STENCILLING : WEEK 17 / YEAR 2007
005 STENCILLING : WEEK 17 / YEAR 2007

HEAD OF LABORATORY,
XAVIER SCHELTJENS



Aleris Aluminium Duffel BVBA